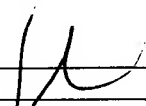
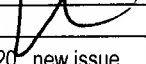


Date: Thursday, 06/09/2007 7:46:21 AM  
User: Linda Lacelle

# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SHUT-OFF VALVE SHAFT
<b>Job Number</b> : 34436	
<b>Estimate Number</b> : 12193	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D3470041
<b>This Issue</b> : 06/09/2007 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3470 REV.A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 28557	<b>Material</b> : N/A
<b>Written By</b> : 	<b>Due Date</b> : 13/09/2007 <b>Qty:</b> 2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : 	
<b>Comment</b> : est rev A 06.04.20 new issue EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	D34703	ARM
-----	--------	-----



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	D3470-3	ARM	B26115

2.0	D34701	SHAFT
-----	--------	-------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	D3470-1	Shaft	B27014

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



**Comment:** LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3470

10/09/06 (2)

4.0	QC9	VISUAL WELDING INSPECTION
-----	-----	---------------------------



**Comment:** VISUAL WELDING INSPECTION

10-09-06 (2)

5.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



**Comment:** INSPECT WORK TO CURRENT STEP

Er 09/09/07 (2)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: P Date: 10/11/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 06/09/2007 7:46:21 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHUT-OFF VALVE SHAFT

Job Number: 34436

Part Number: D3470041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

7/8/10

(22)

SP

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

29/09/11

Job Completion



U 07-09-11

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

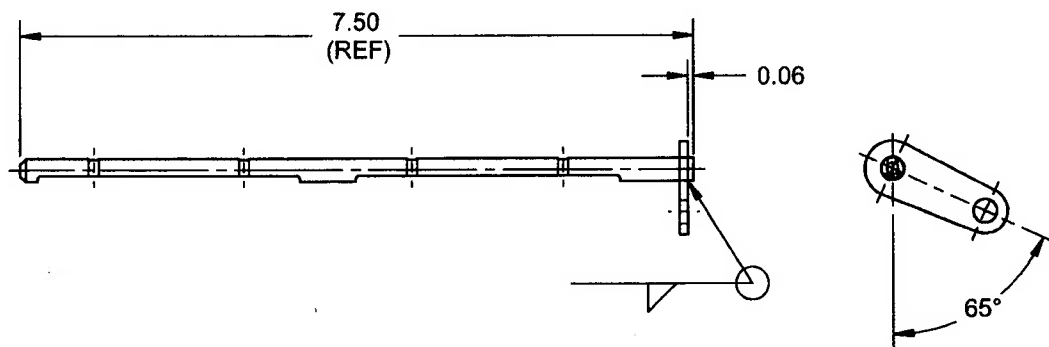
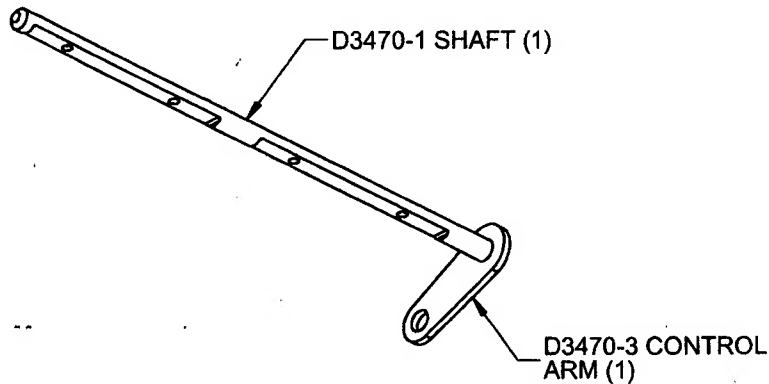
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3470</b>	REV. A SHEET 1 OF 4
DATE <b>05.12.14</b>		TITLE <b>SHUT-OFF VALVE SHAFT</b>	SCALE 1:2
A	05.12.14	NEW ISSUE	

**D3470-041 SHUT-OFF VALVE SHAFT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3470-041	SHUT-OFF VALVE SHAFT
1	D3470-1	SHAFT
1	D3470-3	CONTROL ARM

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

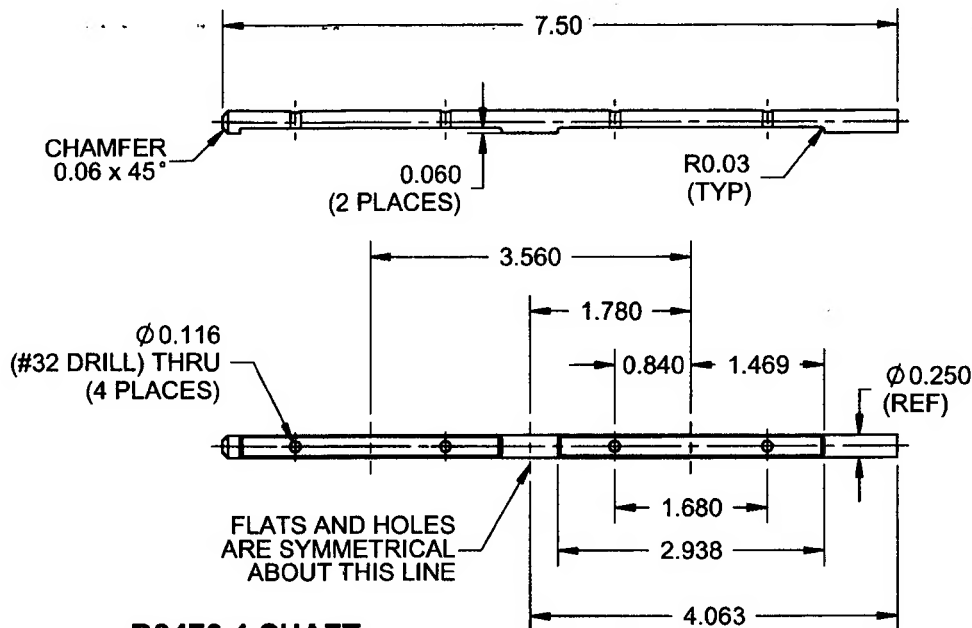
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

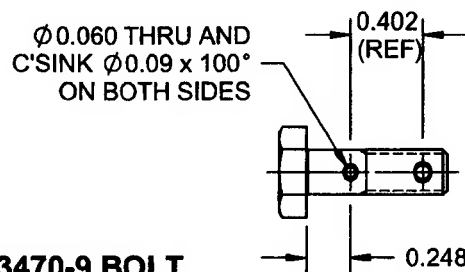
**NOTE:** Date & initial all entries

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DATE <b>05.12.14</b>		TITLE <b>SHUT-OFF VALVE SHAFT</b>	SCALE 1:2

**D3470-1 SHAFT**

- 1) MATERIAL: AISI 303 STAINLESS STEEL 0.25 ROUND BAR  
(REF. DART SPEC. M303R0.250)

**D3470-9 BOLT**

SCALE 1:1

- 1) MAKE FROM AN4-6 BOLT

**NOTES:**

- 2) FINISH: NONE  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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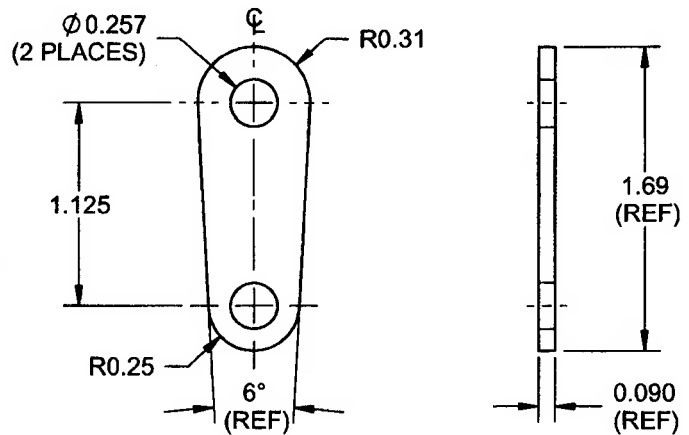
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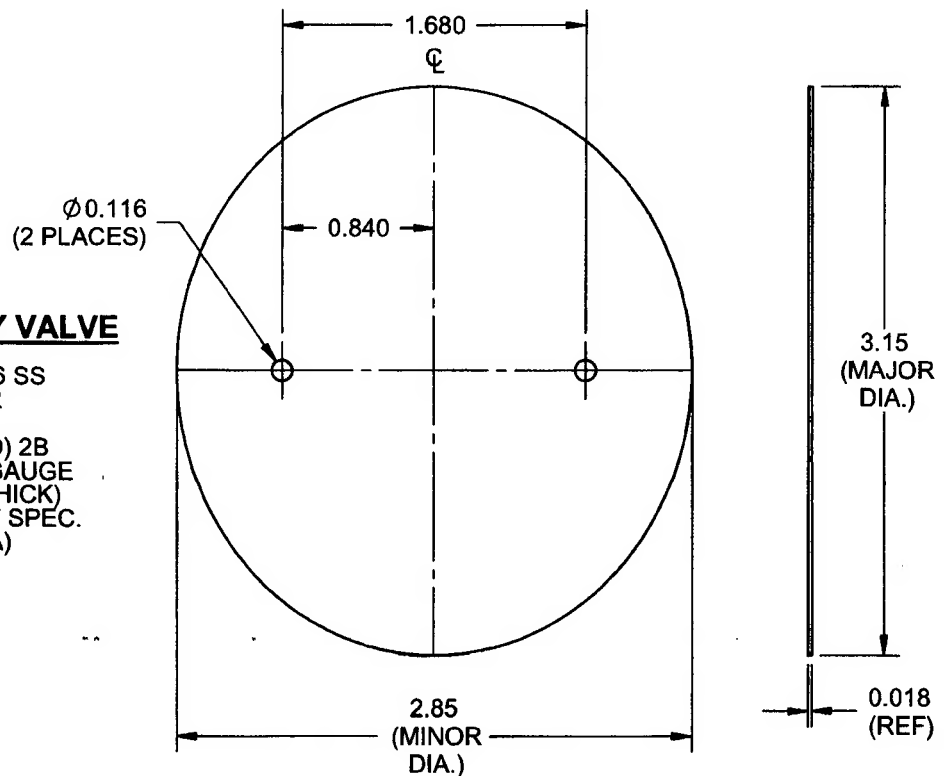
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3470</b>	REV. A SHEET 3 OF 4
DATE <b>05.12.14</b>		TITLE <b>SHUT-OFF VALVE SHAFT</b>	SCALE 1:1

**D3470-3 CONTROL ARM**

- 1) MATERIAL: AISI 304/316 SS SHEET PER  
MIL-S-5019 (ANNEALED) 2B  
FINISH 13 GAUGE SS  
(0.090 THICK)  
(REF. DART SPEC. M304S13GA)

**D3470-5 BUTTERFLY VALVE**

- 1) MATERIAL: AISI 304/316 SS  
SHEET PER  
MIL-S-5019  
(ANNEALED) 2B  
FINISH 26 GAUGE  
SS (0.018 THICK)  
(REF. DART SPEC.  
M304S26GA)

**NOTES:**

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

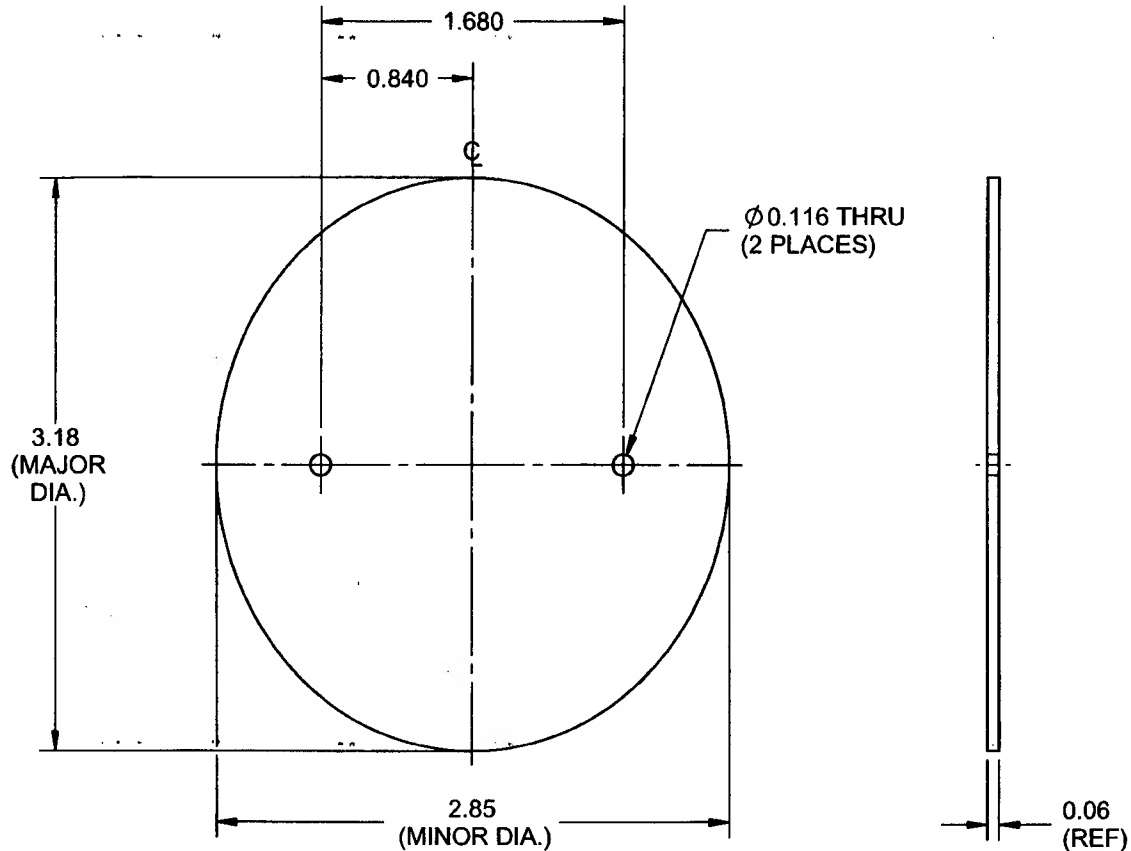
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3470</b>	REV. A SHEET 4 OF 4
DATE <b>05.12.14</b>		TITLE <b>SHUT-OFF VALVE SHAFT</b>	SCALE 1:1

**D3470-7 BUTTERFLY VALVE SEAL****NOTES:**

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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